

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/19	1	Split into 1 piece was made for rest balance 3	SS	27/09/19	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ACCESS PANEL ASSEMBLY
Job Number: 34241		Part Number: D3259042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	D31615	Hinge 9.9" 
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Hinge 9.9" Batch: <u>B 33671</u>		FB 07/09/19
7.0	D32601	Spring 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Spring Batch: <u>B 33678</u>		SB
8.0	127H5	HALF GROMMET 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HALF GROMMET Batch: <u>M 15058</u>		SB
9.0	250018C3Y	RIGHT RECEPTACLE 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) RIGHT RECEPTACLE Batch: <u>M 100034</u>		SB
10.0	2501W20020C3Y	STUD 
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) STUD Batch: <u>M 15131</u>		SB
11.0	MS20426AD44	Rivet 
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Rivet Batch: <u>M 1021</u>		SB
12.0	MS20470AD34	Rivet,Universal Head 
		
Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s) Rivet,Universal Head Batch: <u>M 15541</u>		SD 07/09/19

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NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:20 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34241

Part Number: D3259042

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: M 9682

AS 07/09/09

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



X3

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259 .

Note:Keep .040" Gap all around door.

ml07/11/08

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 182

AS 07/11/09

P

3

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Dart 11/09

Job Completion



u 11.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

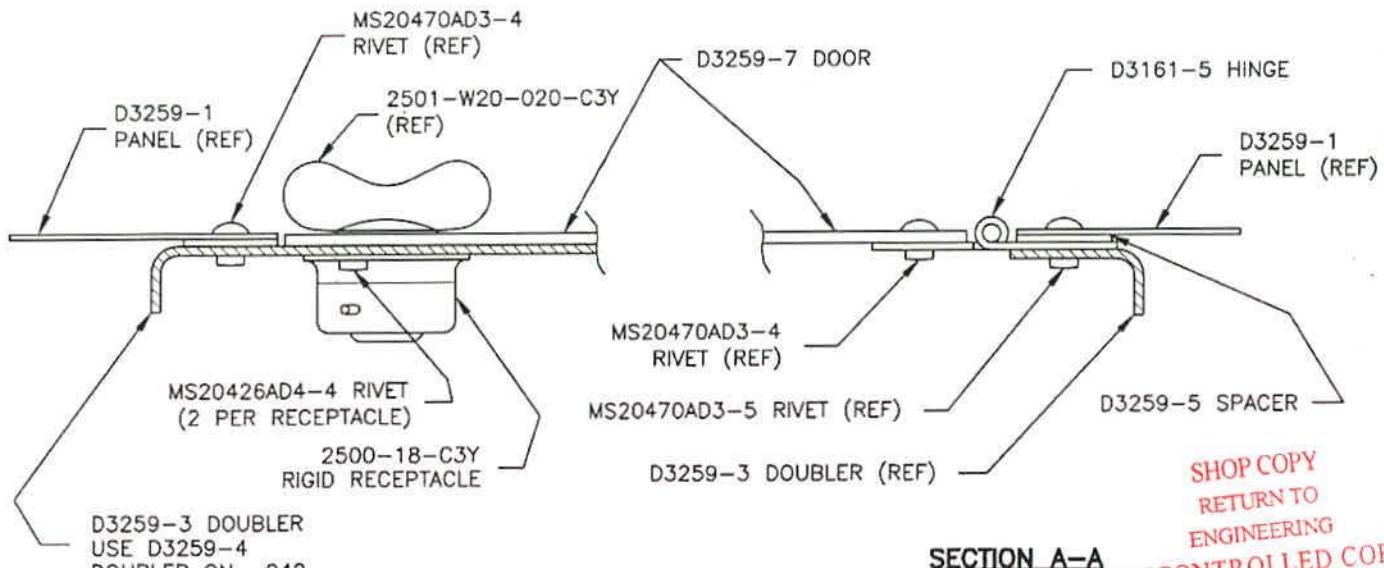
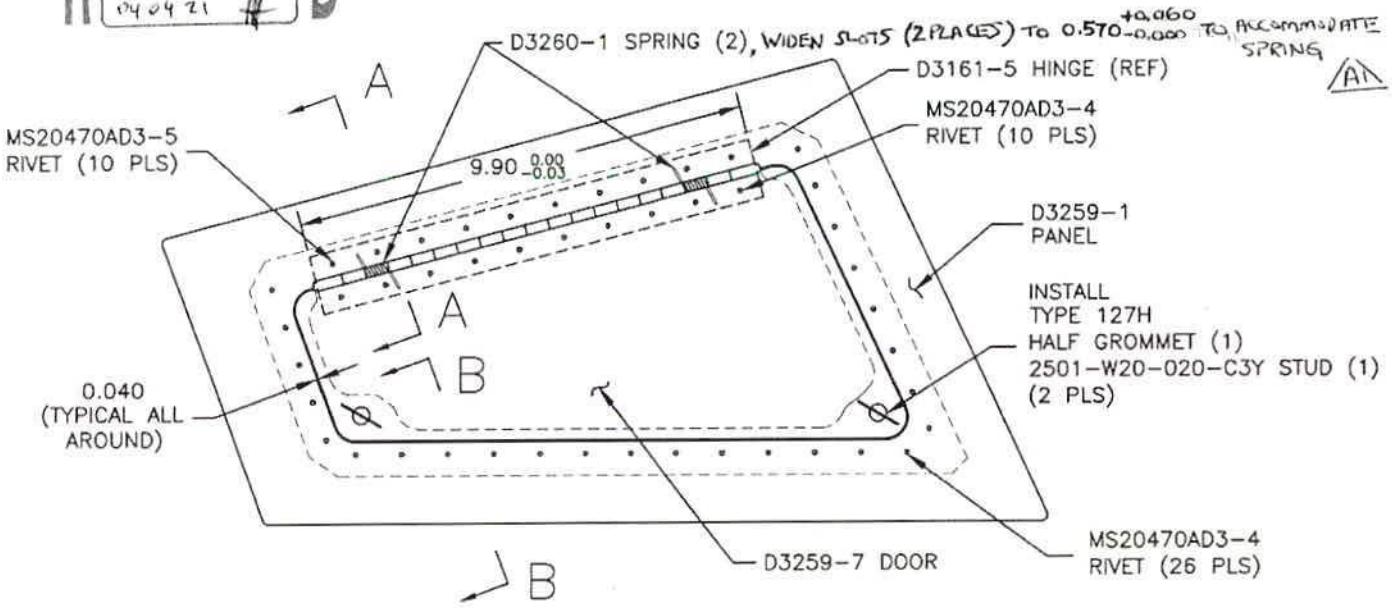
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40

DESIGN RF	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>IP</i>	DRAWING NO. D3259	REV. A SHEET 1 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED

04.02.25

A	04.02.25	NEW ISSUE
A1	<i>IP</i> 04.02.25	WIDEN SLOTS TO ALLOW OPERATION OF SPRING

**SECTION B-B**
VIEW ROTATED**D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)**
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SECTION A-A
VIEW ROTATED **UNCONTROLLED COPY**
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WITHOUT NOTICE
WORK ORDER
NO. *34241*

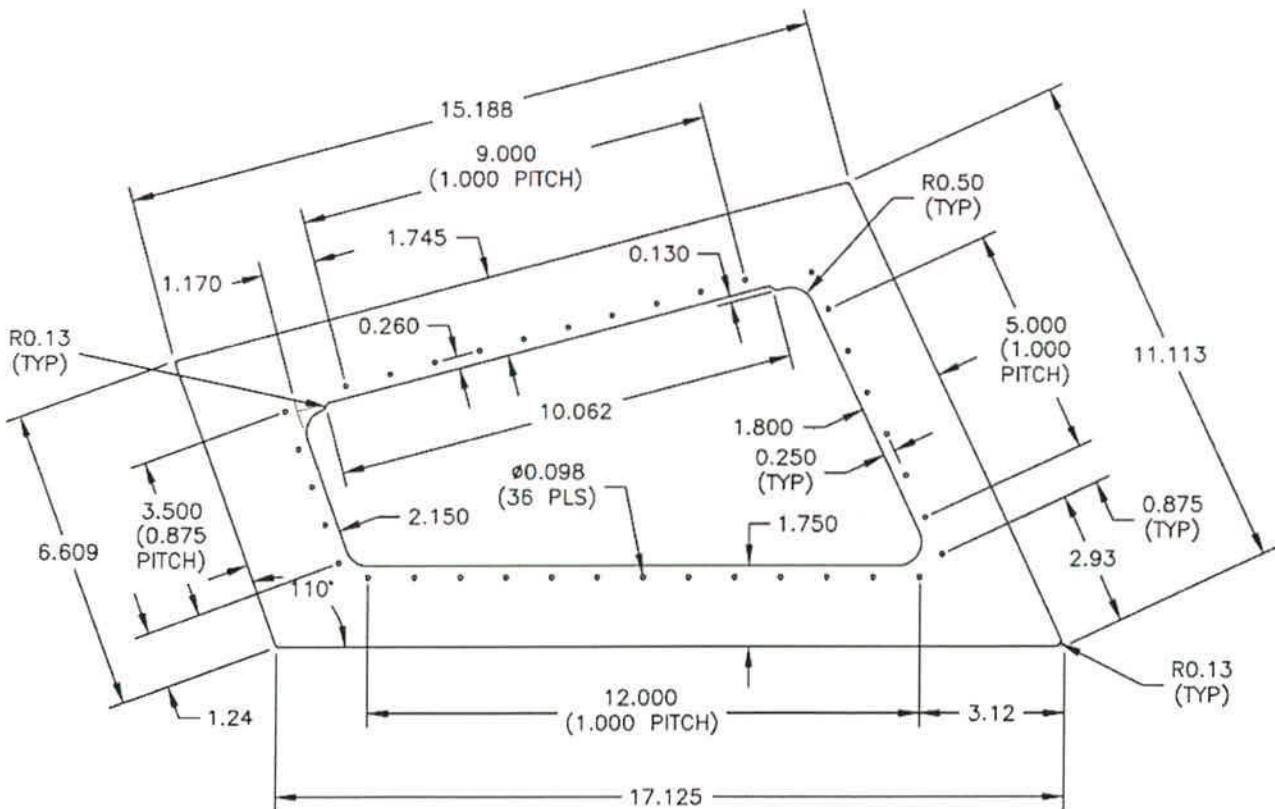
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DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3259	REV. A
DATE	TITLE	SCALE	SHEET 2 OF 6
04.02.25	ACCESS PANEL ASSEMBLY	1:4	

RELEASED
04.04.05**D3259-1 PANEL**NOTES:

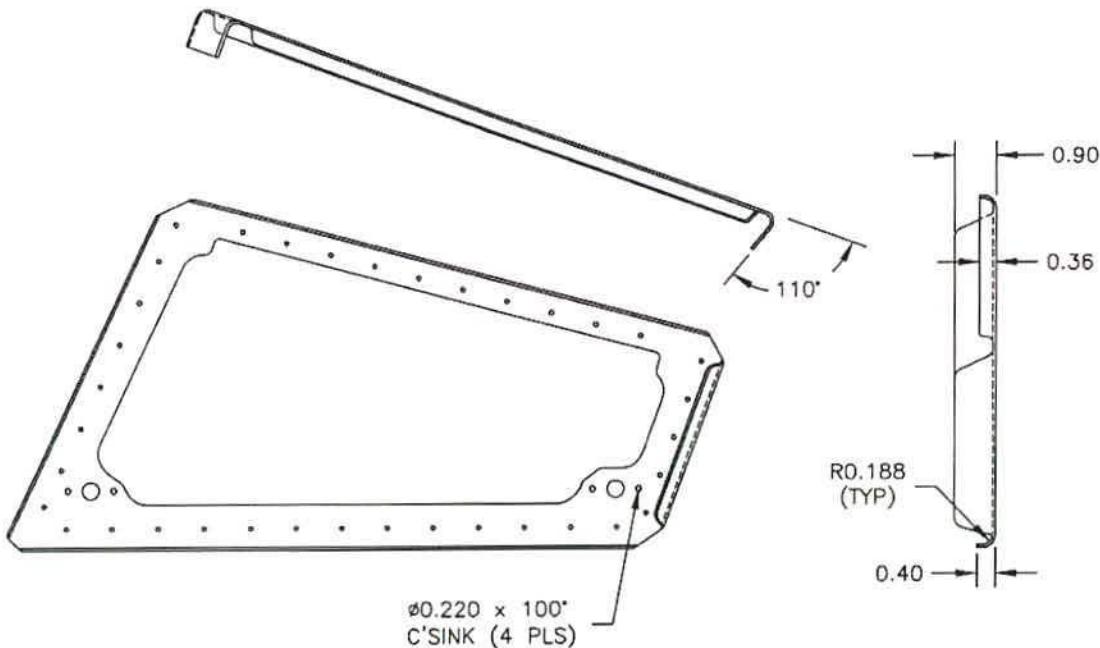
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	04.02.25	TITLE	SCALE 1:4

RELEASED
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

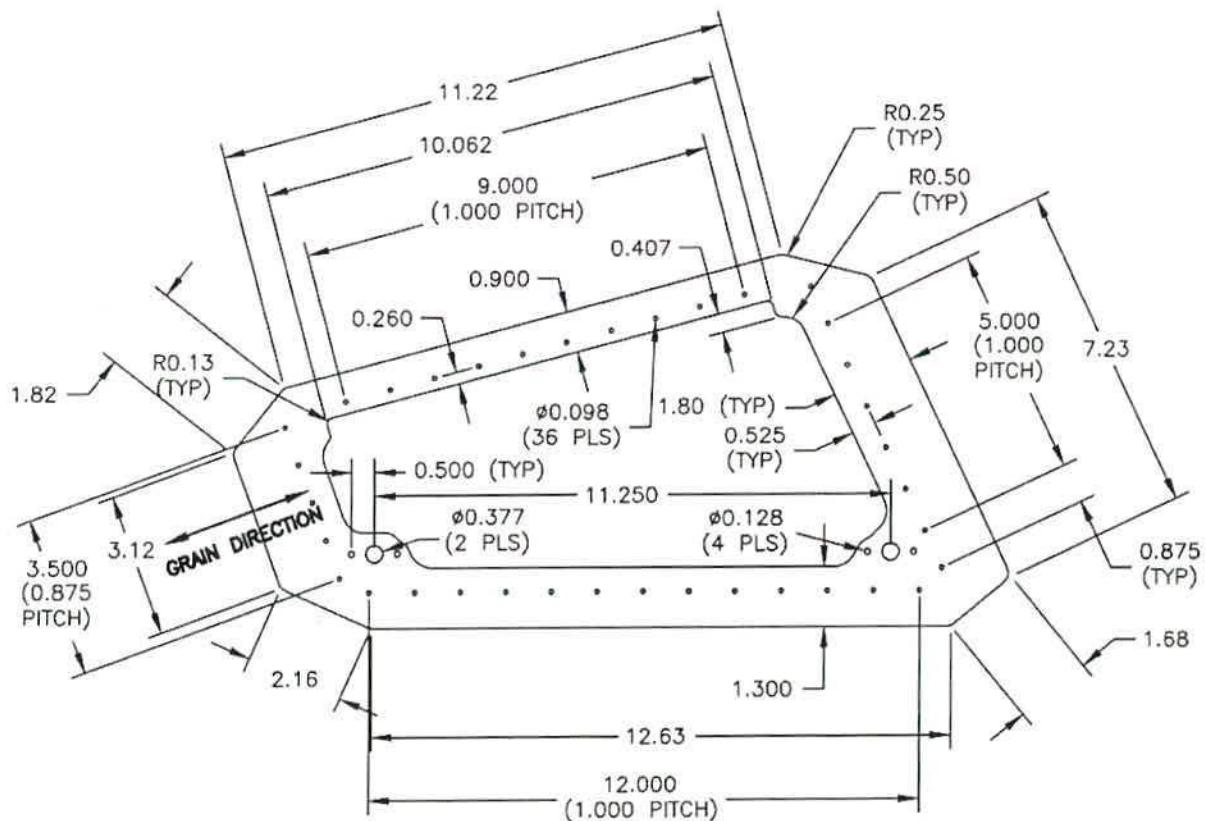
D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		D3259	SHEET 4 OF 6
DATE		TITLE	SCALE
04.02.25		ACCESS PANEL ASSEMBLY	1:4

RELEASED
04 04 14 *sf*

D3259-3/-4 DOUBLER FLAT PATTERN
($\varnothing 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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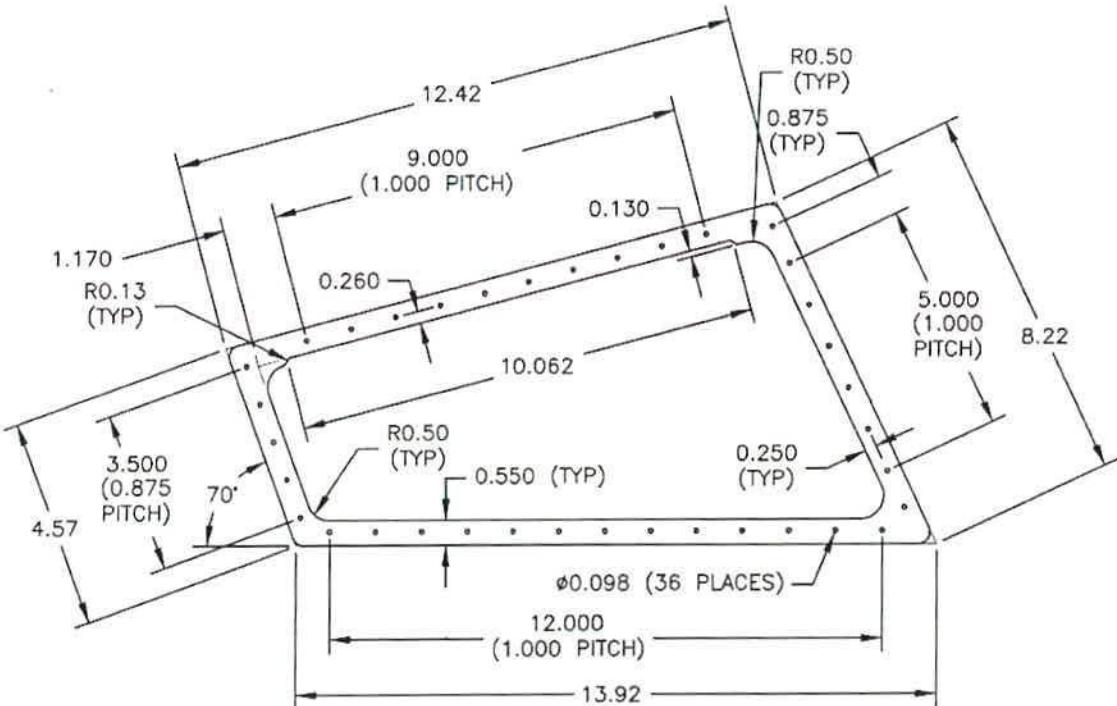
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04.04.05**D3259-5 SPACER**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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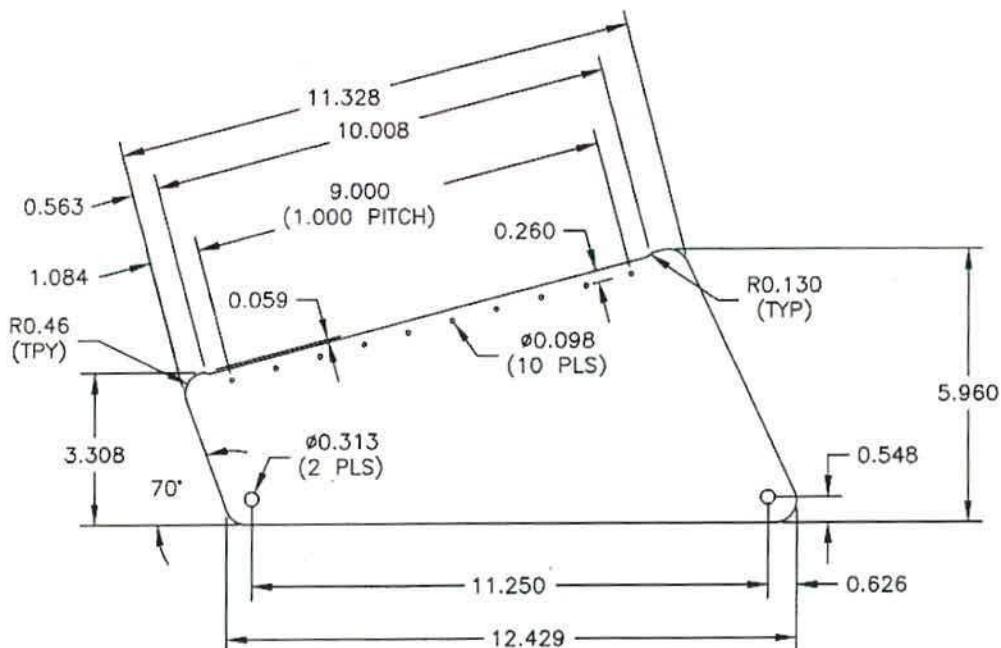
NO. 34241



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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3259	REV. A	SHEET 6 OF 6
DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4	

RELEASED
04-04-14 *[Signature]*

04.04.14 ~~dt~~



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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